

Work Order ID 156377

Friday, January 27, 2017 1:43:10 PM

156377

Page 1

Item ID: D4635-141

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Fwd Ceiling Replacement Panel Assembly, LH

Start Date: 1/23/2017 Start Qty: 1.00

1

Cust Item ID:

Required Date: 1/27/2017 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan:

DAS
21
9-89

Date:

FEB 02 2017

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D4635

F

0.00

100

100

HandThermo

0.14

Memo

Hand Finishing Thermoforming

Pick Kit

DAS
07
9-89

x/

17/03/13

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER : _____							

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Run Start ***NR1***

QC: Date: SPC (Y/N): Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

110

0.01

110

Small Fab

Small Fab

Memo

0.19

Assemble as per Dwg D4635-141

Bond foam core to inside of panel

3M Scotch Weld 1300 Batch: 136812

1- Scuff bonding surface to eliminate in-perfections and increase bonding and clean with wash& wipe

2- Locate and glue down Channel Assy, angles, brackets, and mounting pads using 3M Plastic welder II.(see note 8)

Batch # 137023Expiry Date 17 MAY 29

3- Apply labels as per Dwg. and seal with 3M 3950 edge sealer(see note 9)

Batch: 135435

120

QC5- Inspect part completeness to step on W/O

0.00

120

QC

Quality Control

Memo

0.00

DAS
07
9-89

17/03/13

EB
17-03-16

DQA: _____ Date: _____



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Approvals: Process Plan: Date: Tooling: Date:

Run Start ***NR1***

QC: Date: SPC (Y/N): Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location:

0.00

130

Packaging

Memo

0.00

Packaging

w/o 156423

7/15/17

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.02

Quality Control

17/3/21 JH

JH

MAR 16 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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OTHER : ☐					

Picklist Print

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Page 1

Work Order ID: 156377

156377

Parent Item: D4635-141

D4635-141

Parent Item Name: Fwd Ceiling Replacement Panel Assembly, LH

Start Date: 1/23/2017

Required Date: 1/27/2017

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP Rev. A 12/08/09 New Issue DL
12/11/08 Doc Release DL
Update 13/07/09 DL ver: DD
13/12/09 DL
Ipp Rev. E Dwg Update 14/01/09 DL
Dwg. Update 15/01/27 DL

IPP Rev B
IPP Rev. C Dwg.
IPP Rev D Dwg Update
IPP Rev. F

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D5022-1
D5022-1
Foam, Side Panel, Fwd

Manufactured	No	100	Each	8.0000	1	1							DAS 07 9-89
--------------	----	-----	------	--------	---	---	--	--	--	--	--	--	-------------------

				<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>							
				MF010	8								
				126184	8								

D4635-1
D4635-1
Fwd Ceiling Panel, LH

Manufactured	No	100	Each	0.0000	1	1							DAS 07 9-89
--------------	----	-----	------	--------	---	---	--	--	--	--	--	--	-------------------

D4695-041
D4695-041
Channel Assembly, LH

Manufactured	No	100	Each	2.0000	1	1							DAS 07 9-89
--------------	----	-----	------	--------	---	---	--	--	--	--	--	--	-------------------

				<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>							
				ST446	2								
				125011	2								

D4669-1
D4669-1
Bracket

Manufactured	No	100	Each	8.0000	2	2							DAS 07 9-89
--------------	----	-----	------	--------	---	---	--	--	--	--	--	--	-------------------

				<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>							
				MF004	8								
				125017	8								

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																		
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Root Cause		FAULT CATEGORY																							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	OTHER : ☐																			

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Page 2

Work Order ID: 156377

156377

Parent Item: D4635-141

D4635-141

Parent Item Name: Fwd Ceiling Replacement Panel Assembly, LH

Start Date: 1/23/2017

Required Date: 1/27/2017

Start Qty: 1.00

Required Qty: 1.00

D4732-5 Manufactured No

100 Each 8.0000 1 1

D4732-5

Label

**

DAS
07
9-89

17/03/13

Location

Loc Qty

Loc Code

MF005

8

120062

1

123202

7

D4732-9 Manufactured No

100 Each 7.0000 1 1

D4732-9

Label

**

DAS
07
9-89

17/03/13

Location

Loc Qty

Loc Code

MF005

7

123204

7

D4732-29 Manufactured No

100 Each 7.0000 1 1

D4732-29

Label

**

DAS
07
9-89

17/03/13

Location

Loc Qty

Loc Code

MF005

7

123214

7

D4732-33 Manufactured No

100 Each 7.0000 1 1

D4732-33

Label

**

DAS
07
9-89

17/03/13

Location

Loc Qty

Loc Code

MF005

7

123216

7

Friday, January 27, 2017 1:43:15 PM

Shop Packet Print

Page 2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
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								Lead hand / Supervisor Approval Verification	
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Root Cause			FAULT CATEGORY			
Environment ☐	☐ No Re-verification	☐ Pressure/Forced	☐ Temperature/Cure	☐ Power Loss/Surge	☐ Positioned Wrong	
Design ☐	☐ Operator	☐ Bending	☐ Set-up	☐ Folio/Program	☐ Outside Dimensions	
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Start Date: 1/23/2017

Required Date: 1/27/2017

Start Qty: 1.00

Required Qty: 1.00

MPNY-750S-9-C

Purchased

No

100

Each

695.0000

7

7

MPNY-750S-9-C

Mounting Pad

17/03/13

Location

Loc Qty

Loc Code

ST569

695

M130423

695

7

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Shop Packet Print

Page 3

DQA: _____ Date: _____



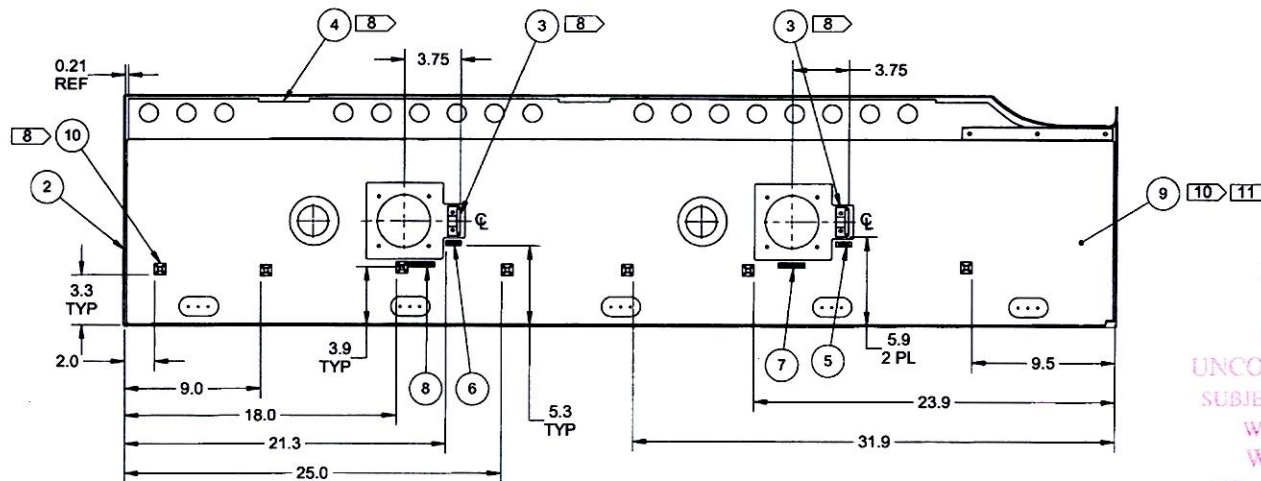
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Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								

ITEM	QTY -141	P/N	DESCRIPTION
1	X	D4635-141	LH, FWD CEILING REPLACEMENT PANEL ASSY
2	1	D4635-1	LH, FWD CEILING PANEL
3	2	D4669-1	BRACKET
4	1	D4695-041	LH CHANNEL ASSEMBLY
5	1	D4732-5	LABEL
6	1	D4732-9	LABEL
7	1	D4732-29	LABEL
8	1	D4732-33	LABEL
9	1	D5022-1	FOAM, SIDE PANEL, FWD
10	7	MPNY-750S-9-C	MOUNTING PAD



D4635-141 LH, FWD CEILING REPLACEMENT PANEL ASSY

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 156377 MLW
170202

RELEASED

2015 JAN 26 up

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A
- 8) APPLY A BEAD (0.20 TO 0.30 WIDE) OF DEVCON PLASTIC WELDER II (0.25 INSIDE OF BOTH EDGES OF PART) TO BOND D4669-1, D4695-041 & MPNY-750S-9C. WAIT FOR 2 TO 4 HOURS FOR FUNCTIONAL CURE
- 9) LOCATE LABELS AS SHOWN, SEAL LABELS USING 3950 EDGE SEALER OVER LABEL TOP SURFACE
- 10) APPLY AN EVEN COAT OF 3M SCOTCH WELD 1300L CONTACT ADHESIVE TO BOND D5022-1 FOAM CORE TO INSIDE OF PANEL
- 11) CENTER D5022-1 FOAM ON D4635-1

APPROVED

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	AK	DRAWING NO. D4635	REV. F
MFG. APPR.	DL		SHEET 9 OF 18
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	OUTBOARD CEILING PANELS	NTS
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